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Erabond 6100 Primer

POLYURETHANE PRIMER

TECHNICAL DATASHEET

Erabond 6100 Primer is a high solids, 2 component urethane primer with outstanding adhesion to properly prepared steel, ductile iron and galvanised substrates. It is specially formulated to provide excellent anti corrosive properties and accept fast-set and standard-set polyurethanes.

Features

- Convenient 1:1 mix ratio
- Excellent adhesion to aged Polyurethane and Polyurea coatings
- Very good chemical resistance
- High flexibility and impact resistance
- Prevents undercutting

Product Specification

Mix Ratio (Volume)	1:1
Potlife at 15°C	1.5-2 hrs
Potlife at 24°C	1-1.5 hrs
Potlife at 32°C	0.5-1 hrs
Solids Content by Volume	55%
Solids Content by Weight	68%
Theoretical Coverage 1 Litre	20m ² at 25µm
Recommended Dry Film Thickness (DFT)	25µm - 75µm
Number of Coats required	1



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Surface Preparation

It is essential to remove all oil, grease, cutting / drilling compounds, and other surface contaminants prior to further preparation of the metal surface. This is achieved using a biodegradable degreasing solution in accordance with AS1627.1. Alternatively solvent wiping using a solvent-based degreaser can be used. Clean dry untreated rags must be used and changed regularly to ensure the oil is removed and not spread over a larger area.

Soluble salts and biodegradable degreasing solution residue shall be removed by low pressure water washing (approx. 20 MPa) using potable water.

Grind all sharp edges and corners to a minimum radius of 2mm. Remove all weld slag and spatter, and grind all weld seams and high spots smooth.

Mild Steel

Abrasive blast all surfaces in accordance with AS1627.4 to a minimum Sa2½ (AS1627.9). A surface profile of 50 – 75 µm shall be achieved. Dust / vacuum down to remove all preparation residues. Blasted surfaces shall be primed prior to surface deterioration or contamination. The surface shall resemble the specified visual standard and profile immediately prior to priming.

Aluminium, Galvanized Steel, Stainless Steel

Low pressure sweep abrasive blast using inert media (e.g. garnet) to achieve a roughened uniform flat appearance over the entire surface. Dust / vacuum down to remove all preparation residues. Blasted surfaces shall be primed with four hours, and before surface contamination occurs.

Other Metals

Test patches of the complete coating system should be examined and tested for adhesion to ensure suitability of Erabond 6100 Primer for other metallic surfaces.

Product Mixing

The mix ratio of **Erabond 6100 Primer** is 1:1 by volume. Each component needs to be mechanically mixed before adding together. They should be combined at a 1:1 ratio and mechanically mixed to a smooth consistency.

Addition of Thinners

Addition of thinners to **Erabond 6100 Primer** is not normally required.

Application Instructions

Erabond 6100 Primer is best applied by siphon or pressure pot spray equipment. Airless spray equipment may be used, provided a minimum of 25µm DFT is applied.

Erabond 6100 Primer is applied in a single wet pass with 50% overlap. Hold the gun at right angles to the surface approx. 20-30 cm away. Make even, parallel passes and spray approx. 80µm Wet Film Thickness (WFT) to achieve approximately 40 µm DFT. A thick film is not required. The desired film thickness will be obtained when the film appearance is continuous, but mottled and translucent.

Clean Up

Clean all mixing and application equipment immediately after use with MEK.

Cure Time

Cure time is based on 25µ - 75µ dry film thickness at 30 -50% Humidity.

Excessive film thickness, cooler temperatures or poor ventilation may require longer cure times resulting in premature failure.

	50 – 60°F (10 – 15°C)	70 – 80°F (21 – 27°C)	90 – 100°F (32 – 38°C)
Surface Dry	12 – 18 hrs	6 – 10 hrs	3 – 5 hrs
Hard Film	18 – 24 hrs	10 – 12 hrs	4 – 6 hrs
Recoat (min)	18 – 24 hrs	10 – 12 hrs	4 – 6 hrs
Recoat (max)	24 hrs	24 hrs	24 hrs
Full cure	5 days	4 days	3 days

Handling Precautions

Before handling these chemicals please consult the **Erabond 6100 Primer** Material Safety Data Sheet.

Erabond 6100 Primer is flammable and should be kept away from all heat and ignition sources.

Adequate ventilation is required (see the MSDS) with approved engineering controls and personal protective equipment.

Contact with the skin or eyes must be avoided and avoid breathing in vapour or spray.

The appropriate PPE should be worn whenever handling the chemicals.